



Dart Aerospace Ltd.
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D3793-3

Job Sheet 194967



Part No: D3793-3

Job Qty: 10 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 5/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3793 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-23 revA as per dwg
DD verified by:EC IPP REV:C 18.11.09 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		5/21/19	0.00	1.31	Waterjet - Flow		DC 19/06/04
110	QC 2	10 pcs		5/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 19/06/04
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120	QC 8	10 pcs	5/21/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	JUN 05 2019 40
					QC 8 - 52	9-89
					QC 8 - 23	
130	Small Fab - Brake NC - B4B	10 pcs	5/21/19	0.15 0.32	Small Fab - Brake - 1 - B4B	DAS 30 JUN 11 2019
					Small Fab - Brake - 2 - B4B	9-89
					Small Fab - Brake - 3 - B4B	
140	QC 5	10 pcs	5/21/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JUN 12 2019 40
						AS 19-6-12 9-89
150	Spray Paint - 2 - B4B	10 pcs	5/21/19	0.00 1.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 3	10 pcs	5/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	

				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	JUN 13 2019
				QC 3 - 19	DAS 40 9-89
				QC 3 - 43	
				QC 3 - 24	
170	Packaging 3-1 - Stock - B4B	10 pcs	5/21/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	10 pcs	5/21/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Cut as per Dwg D3793 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 140 - (QC5- Inspect part completeness to step on W/O) 150 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI					

BATCH: 5178850

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	12.8280 sf (1.2828 ea)	100-Waterjet - Flow - 1	5175151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	13	258	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	194968
Description: Wearshoe		Part Number:	D3793-3
Inspection Dwg: D3793 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.187	✓		VDC-02	
0.300	+/-0.010	0.301	✓			
1.89	+/-0.010	1.896	✓			
4.389	+/-0.010	4.392	✓			
6.55	+/-0.010	6.548	✓			
6.00	+/-0.030	6.00	✓			
6.75	+/-0.030	6.75	✓			
2.000	+/-0.010	2.001	✓			
4.750	+/-0.010	4.749	✓			
9.500	+/-0.010	9.500	✓			
14.250	+/-0.010	14.250	✓			
17.750	+/-0.010	17.750	✓			
26.735	+/-0.010	26.735	✓			
Ø0.531 x 0.780	+0.008/-0.001	.531 x .780	✓			
0.330	+/-0.010	.330	✓			

Measured by: JRB	Audited by: DAS 40 9-89	Prototype Approval:	N/A
Date: 06/5/19	Date: JUN 05 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	
B	19.01.22	Revision and dimension changes.	MG	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S187517



Part: D3793-3

Job No: 194967

Serial No/Batch: S187517

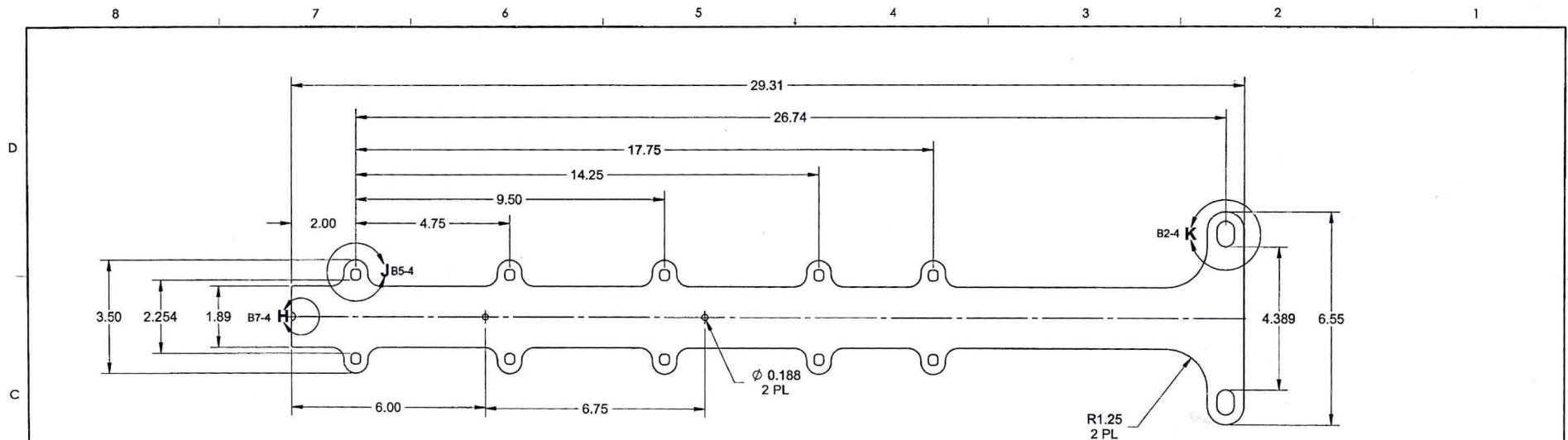
Revision: B

Inspector:

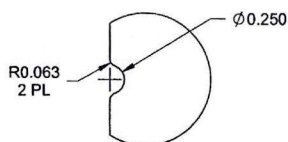
Exp Date:

Instructions: Various STC's

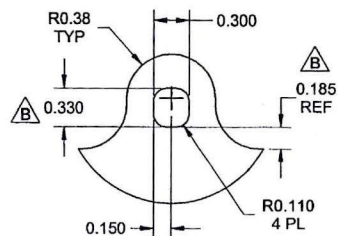
Date: 06/04/19



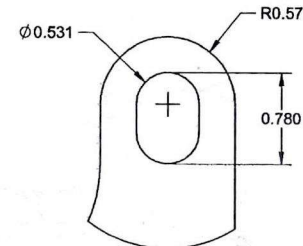
D3793-3F FLAT PATTERN



DETAIL H C7-4
TOOLING NOTCH
SCALE 3X



DETAIL J D7-4
SCALE 3X, 10 PL



DETAIL K D2-4
SCALE 3X, 2 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE (0.038 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.71 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE "D3793-3F-REV.B .DXF"

RELEASED

2018 OCT 19

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. B
MFG. APPR.	DD	D3793	SHEET 4 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARSHOE	NTS
DATE	18.05.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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